

| | | | |
|-----------------------|--|------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DOUBLER |
| Job Number | : 34819 | | |
| Estimate Number | : 11169 | | |
| P.O. Number | : N/A | Part Number | : D32831 |
| This Issue | : 9/21/2007 S.O. No. : N/A | Drawing Number | : D3283 REV E |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 9/21/2007 Type : SMALL /MED FAB | Drawing Revision | : E |
| Previous Run | : 33717 | Material | : N/A |
| Written By | : <u>[Signature]</u> | Due Date | : 10/5/2007 Qty: 30 Um: Each |
| Checked & Approved By | : <u>[Signature]</u> | | |
| Comment | : Est A 04.09.28 New issue KJ/JLM | | |
| | Est Rev:B Now on Waterjet 07-05-28 JLM | | |
| | Est Rev:C As per Rev E 07-09-09 JLM Verified By:EC | | |

Job Number:



1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.2479 sf(s)/Unit Total : 7.4372 sf(s)
6061-T6 .063 Sheet
Material: 6061-T6 (QQ-A-250/11) 0.063" thick
(M6061T6S.063)
Identify for D3283-1
Batch: M105225 1B 3-

30

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3283
Dwg Rev: E
Prog Rev: E

1B 07-10-44

2-Deburr if necessary 1B 07-10-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40 QC8 SECOND CHECK



Comment: SECOND CHECK

5 A/1064 (+3) counts.

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 9/10/11
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:18:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 34819

Part Number: D32831

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

MLA

07/10/05

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MLA

07/10/05

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-L

07/10/09

(30X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/10/09 (30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/10/09 (30)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/11

(30)

Job Completion



07/10/10

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

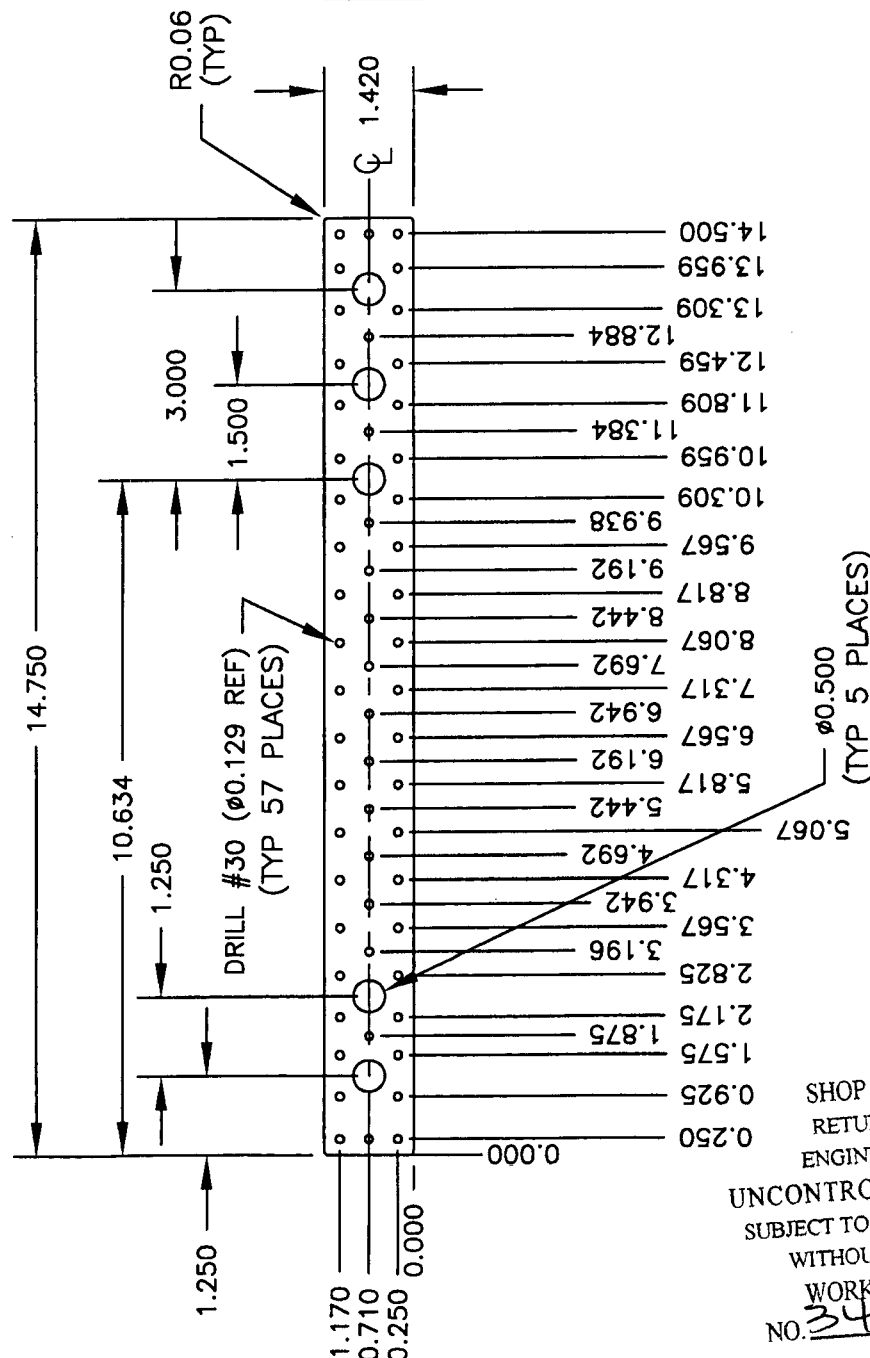
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
07.08.27 PM
PER ECN 959

| | | | | | |
|------------------|----------|-------------------------------------|--|--|--|
| DESIGN GP | | DRAWN BY DC | | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED B | | APPROVED H | | DRAWING NO. D3283 | |
| DATE 07.06.01 | | TITLE DOUBLER | | REV. E SHEET 1 OF 2 | |
| A | 04.05.06 | NEW ISSUE | | | |
| B | 04.08.09 | 10.882 WAS 11.502 | | | |
| C | 05.03.16 | CHANGE HOLE PATTERN FOR -1 | | | |
| D | 05.08.09 | REDESIGN | | | |
| E | 07.06.01 | MISSING HOLE ADDED © (7.692, 0.710) | | | |



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WORK ORDER
NO. 34819

D3283-1 DOUBLER

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

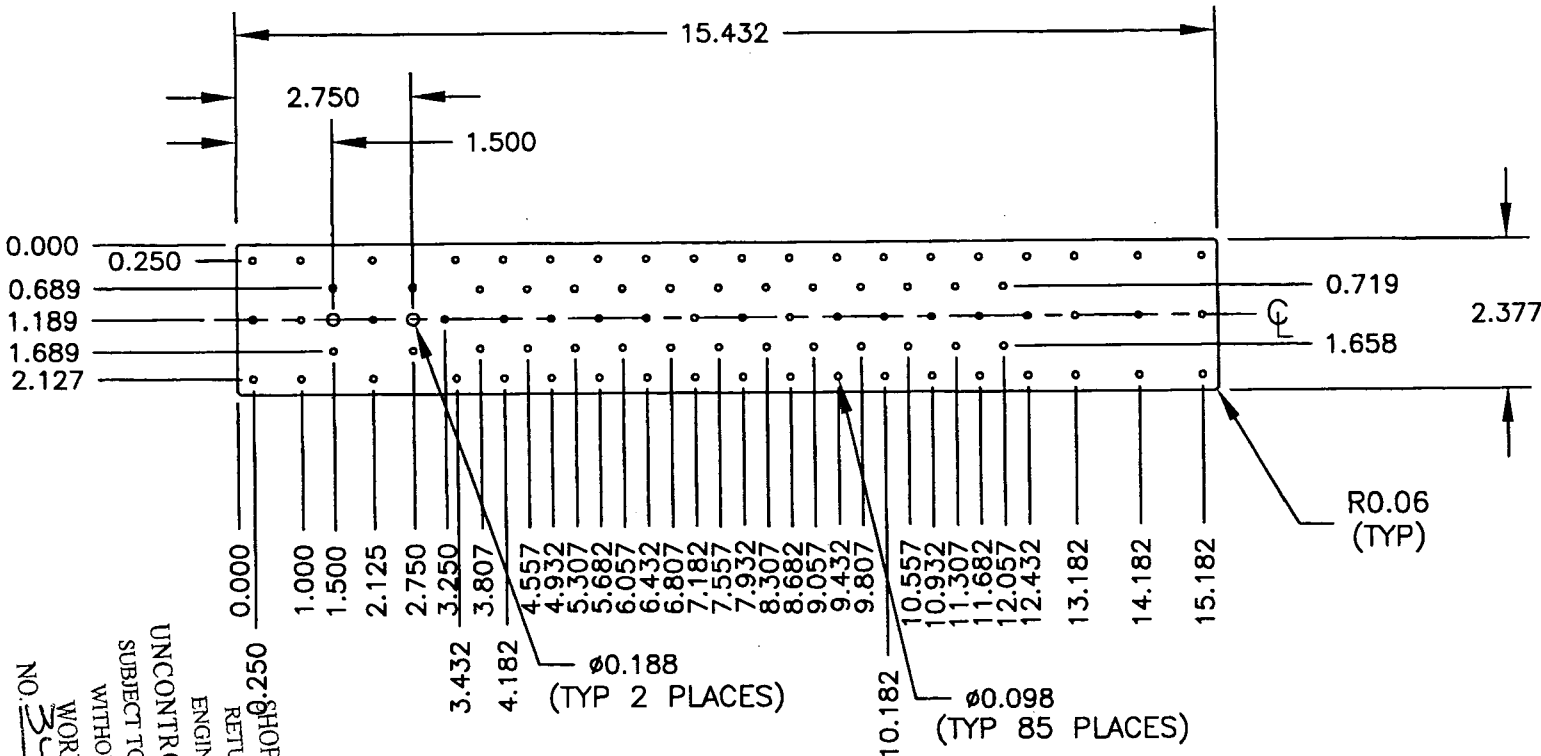
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| | | | |
|----------|----------|--------------------------|------------------|
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | |
| CHECKED | APPROVED | DRAWING NO. | PORT HADLOCK, WA |
| DATE | | TITLE | REV. E |
| 07.06.01 | | DOUBLER | SHEET 2 OF 2 |
| | | | SCALE |
| | | | 1:3 |

RELEASED
07.08.99
PER ECN 959



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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